

Order ID 102270

3 12:42:37 PM

102270

Page 1

D3183-045

ID:

ie: Bearing Assembly

e: 5/30/13 Start Qty: 20.00

Date: 5/30/13 Req'd Qty: 20.00

::

s: Process Plan: M03

Date: 5/30/13

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

ID/
ter ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

br Revision Nbr

Rev C1

* Hardinge CNC LATHE SMALL

0.00

Memo

0.00

FK 13/05/30

60

IC Lathe Small

Turn D3183-9 Cap as per Folio FA3881Deburr

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

FK 13/05/30

60

QC8- Inspect parts - second check

0.00

Memo

0.00

SL 13-5-30

60

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

20

20

Split

Accept

22

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Item ID: D3183-045

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Bearing Assembly

Start Date: 5/30/13 Start Qty: 20.00

20

Cust Item ID:

Required Date: 5/30/13 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

130

0.00

130

Small Fab

Small Fab

Memo

0.00

Small Fab

Press D3183-5 Bearing into D3183-9 Cap as per Dwg D3183.

22

13/06/14

140

0.00

140

QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

22

22

150

0.00

150

Packaging

Identify as per dwg & Stock Location:

Memo

0.00

Packaging

5235 B

Work Order ID 102270

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Item ID: D3183-045

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Bearing Assembly

Start Date: 5/30/13 Start Qty: 20.00

20

Cust Item ID:

Required Date: 5/30/13 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

MJ 13-06-07
ME 13-6-4

Picklist Print

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Work Order ID: 102270
 Parent Item: D3183-045
 Parent Item Name: Bearing Assembly

Start Date: 5/30/13
 Start Qty: 20.00

Required Date: 5/30/13
 Required Qty: 20.00

Comments: IPP A04.02.18New issueKJ/DS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3183-5 Bearing		Manufactured	No			110	Each	48.0000	1	20			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST235B		48							
				98653		48							
MDELINR1.000 Delrin Round Bar 1"		Purchased	No			130	F	41.5670	0.0333	0.701052			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT018		41.567							
				125251		41.567							

Handwritten: 5/30/13

Handwritten: 22

Handwritten: 2.103

Handwritten: FK 13/05/130

DRAWING NO. D3183	TITLE BRACKET ASSEMBLY	REV. C1	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3183-01-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN JP	CHECKED M	MFG. APPR. M	APPROVED MP		DE APPR. M		
DATE 10.05.14	DATE 10.06.30	DATE 10.06.30	DATE 10/06/30		DATE 10/06/30		

D3183-5 BEARING

ADD POSSIBLE SUPPLIER: KML P/N 6800-ZZ

BASIC LOAD RATING REQUIREMENT: Cr = 1720 N (386 lb) MIN [DYNAMIC]
Cor = 840 N (188 lb) MIN [STATIC]

REF PAR 10-012

RELEASED
2010-07-22
MP

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